



Dart Aerospace Ltd.
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D4635-144

Job Sheet 167086-C



Part No: D4635-144

Job Qty: 1 ea

Part Name: Aft Ceiling Replacement Panel Assembly, RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV F SHEET 12 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL verf:DD IPP Rev D Dwg Update 13/12/09 DL lpp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start Up Container		
100	HandThermo	1 pcs		11/9/17	0.00	1.16	HandFinish4		
110	Small Fab	1 pcs		11/10/17	0.00	1.57	Small Fab		
120	QC	1 pcs		11/10/17	0.00	0.00	QC5		
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3		
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21		

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-144 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4635-4 5022740	1	3	0	0
	D4669-1 5024331	1	31	0	0
	D4695-4 5022739	1	7	0	0
	D4732-11 5022738	1	9	0	0
	D4732-39 5022737	1	8	0	0
	D4732-41 5022736	1	8	0	0
	D5022-5 5022736	1	7	0	0

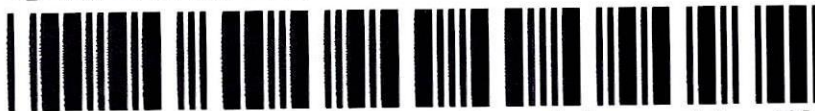
Part Specifications

Specifications could not be found.

DART
AEROSPACE
S026629

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Aft Ceiling Replacement Panel Assembly, RH

PART NO: D4635 – 144

Revision:

Operation: QC21 – SA

Change No:

Mfg Date: 12/22/17

Job No: 167086 – C